

Listing of the Claims:

1. (Currently Amended) Process for manufacturing a cooling channel piston which has a cooling channel approximately in the area behind a ring belt, where a piston blank is shaped at least partially in a forging process, characterized in that specifically in the approximate area of a top land, at least one circumferential shoulder having a terminating free end spaced from the piston blank and having a length less than a length of the piston blank and projecting laterally from one portion of the piston blank is formed, behind the at least one shoulder a recess is introduced from a side of the piston blank and then the at least one shoulder is reshaped by means of deformation such that the recess is closed by the at least one shoulder with the terminating free end of the at least one shoulder directly connected to another portion of the piston blank to create the cooling channel.

2. (Original) Process in accordance with claim 1, wherein the reshaping takes place by forging.

3. (Original) Process in accordance with claim 1, wherein the reshaping takes place by swaging.

4. (Original) Process in accordance with claim 1, wherein the reshaping takes place by driving through a hollow form.

5. (Original) Process in accordance with claim 1, wherein the reshaping takes place by pressure rolling.

6. (Currently Amended) Process in accordance with claim 1, wherein the terminating end of the at least one shoulder is rigidly connected to said other portion of the piston blank or to another shoulder forming a contact area.

7. (Original) Process in accordance with claim 6, wherein the contact area is reworked.

8. (Previously Presented) Process in accordance with claim 6, wherein the shoulder is furnished with sealing means in the contact area with respect to the piston blank.